

## CLAIMS

1. Method of making hot strips of a workable lightweight construction steel which in particular can be easily deep-drawn cold, comprising the main elements Si, Al and Mn, and having a high tensile strength and TRIP and/or TWIP characteristics, characterized in  
that the contents in mass-% amount for

C      0.04 to  $\leq$  1.0  
Al     0.05 to < 4.0  
Si     0.05 to  $\leq$  6.0  
Mn    9.0 to  $\leq$  30.0,

the remainder being iron including common incidental steel elements, wherein a melt is cast in a horizontal strip casting unit, close to final dimensions at calm flow and without bending, to form a pre-strip in the range between 6 and 15 mm, and subsequently is fed for further processing.
2. Method according to claim 1,  
characterized in  
that the carbon content amounts to 0.06 to  $\leq$  0.7 %.
3. Method according to claim 1 and 2,  
characterized in  
that the steel contains Cr up to  $\leq$  6.5 %.
4. Method according to claim 1 - 3,  
characterized in  
that the Mn content amounts to 9 - 18 %.

5. Method according to claim 1 - 3,  
characterized in  
that the Mn content amounts to 18 - 22 %.
  
6. Method according to claim 3 - 5,  
characterized in  
that the Cr content amounts to 0.3 - 1.0 %.
  
7. Method according to claim 1 - 3,  
characterized in  
that the Mn content amounts to 22 - 30 %.
  
8. Method according to claim 3 and 7,  
characterized in  
that the Cr content amounts to 0.05 - 0.2 %.
  
9. Method according to the claims 1-8,  
characterized in  
that the Si content amounts to 2.0 - 4.0 %.
  
10. Method according to the claims 1 - 9,  
characterized in  
that the Al content amounts to 2.0 - 3.0 %.
  
11. Method according to the claims 1 - 10,  
characterized in  
that the hydrogen content amounts to < 20 ppm.

12. Method according to claim 11,  
characterized in  
that the hydrogen content amounts to < 5 ppm.
13. Method according to the claims 1 - 12,  
characterized in  
that Cu up to  $\leq$  4 % is optionally contained.
14. Method according to the claims 1 - 13,  
characterized in  
that titanium and zirconium in total of up to  $\leq$  0.7 % are optionally contained.
15. Method according to the claims 1 - 12,  
characterized in  
that niobium and vanadium in total of up to  $\leq$  0.06 % are optionally contained.
16. Method according to the claims 14 and 15,  
characterized in  
that titanium, zirconium, niobium and vanadium in total of up to  $\leq$  0.8 % are  
optionally contained.
17. Method according to one of the claims 1 - 16,  
characterized in  
that the speed of the melt feed is identical to the speed of the revolving  
conveyor band.

18. Method according to one of the claims 1 - 17,  
characterized in  
that the strand shell of a strip, which extends across the width of the conveyor band, is forming as solidification commences, with all surface elements of the strand shell subjected to substantially identical cool-down conditions.
  
19. Method according to one of the claims 1 - 18,  
characterized in  
that the melt being placed on the conveyor band is substantially through solidified at the end of the conveyor band.
  
20. Method according to claim 1 and 19,  
characterized in  
that following the through solidification and before commencement of the further processing, the pre-strip advances through a homogenization zone.
  
21. Method according to claim 1 and 20,  
characterized in  
that the further processing involves a coiling of the pre-strip.
  
22. Method according to claim 1 and 20,  
characterized in  
that the pre-strip undergoes inline a rolling process and is then coiled up.
  
23. Method according to claim 1 and 20,  
characterized in  
that the deformation degree is at least 50 %, preferably > 70 %.